

Date: Monday, 6/5/2006 11:00:38 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : OH-58 STEP ASSY RH *UNDER REVIEW**
 Job Number : 27399
 Estimate Number : 12439
 P.O. Number : N/A Part Number : D058677012
 This Issue : 6/5/2006 S.O. No. : N/A Drawing Number : D2943 UNDER REVIEW
 Prsht Rev. : NC Project Number : N/A
 First Issue : N/A Type : LARGE FAB ASSY Drawing Revision : UNDER B
 Previous Run : N/A Material : N/A
 Written By : SEE COMMENT BELOW Due Date : 6/12/2006 Qty: 4 Um: Each
 Checked & Approved By : 06.06.05
 Comment : Est Rev:B 01.04.11 Combined with D2943-041 EC

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	DC	DOCUMENT CONTROL



Comment: Photocopy bluefile & type labels per PPPD058-677-012 CHG

KT 06.06.06. (4)

2.0

D2622120C

Extrusion



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

Extrusion D2622-120C

Batch: 327077

PE 06.06.05 4

3.0

D2734

206 Step Endplate



Comment: Qty.: 2.0000 Each(s)/Unit Total: 8.0000 Each(s)

D2734 206 Step Endplate

Batch: 324402

PE 06.06.05 4

4.0

D2725

206 Step Lug



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

D2725 206 Step Lug

Batch: 320783

PE 06.06.05 4

5.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Cut D2943-1 from D2622 extrusion as per Dwg D2943

2-Deburr and bevel ends for welding

3-Weld end cap(1) and plate as per Dwg D2943 using Jig DT 8482

PE 06.06.05 4
 PE 06.06.05 4
 PE 06.06.06 4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

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Drawing Name: OH-58 STEP ASSY RH *UNDER REVIEW**

Job Number: 27399

Part Number: D058677012

Job Number:



Seq. #:

Machine Or Operation:

Description :

A/R AL ROD

Batch:

M15689
M19173

4-Grind end cap welds flush as per dwg D2943

P.E. 06-06-06
P.E. 06-06-06
FF 06-06-06

6.0

QC5/9

WELD INSPECTION



J 06-06-06 (4)



PD 06-06-06

Comment: WELD INSPECTION

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

FF 06.06.06

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

9.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Weld last end cap(1) as per Dwg D2943 using Jig DT 8482

A/R AL ROD

Batch:

M15689

2-Grind end cap welds flush as per dwg D2943

P.E. 06-06-06

10.0

QC5/9

WELD INSPECTION



J 06-06-07 (4)



PD 06-06-07

Comment: WELD INSPECTION

11.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Touch up Chemical Conversion Coat as per QSI 005 4.1

DL 06/06/07 (4)

12.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

G.M. 06-06-07 (4)

W/O:		WORK ORDER CHANGES					
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NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

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Job Number: 27399

Part Number: D058677012

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Wing Walk as per Dwg D2943 and QSI 005 4.4

Batch: M100652

R.M. 06-06-07

(8)

14.0

QC3/5

INSPECT WORK/WING WALK



Comment: INSPECT WORK/WING WALK

FL 06 06 08

15.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

16.0

D27311

Mounting Lug



Comment: Qty.: 2.0000 Each(s)/Unit Total: 8.0000 Each(s)

Mounting Lug

Batch: B15282 ✓

17.0

D27313

Mounting Lug



Comment: Qty.: 2.0000 Each(s)/Unit Total: 8.0000 Each(s)

Mounting Lug

B14652 ✓

18.0

D27315

Mounting Lug



Comment: Qty.: 2.0000 Each(s)/Unit Total: 8.0000 Each(s)

Mounting Lug

Batch: B14652 B23330 ✓

19.0

D27317

Mounting Lug



Comment: Qty.: 2.0000 Each(s)/Unit Total: 8.0000 Each(s)

Mounting Lug

Batch: B22592 ✓

W/O:		WORK ORDER CHANGES					
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 26/10/19

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

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User: Kim Johnston

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Part Number: D058677012

Job Number:



Seq. #:

Machine Or Operation:

Description :

20.0

AN411A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 16.0000 Each(s)

Bolt

Batch: M1771 ✓

21.0

AN412A

Bolt



Comment: Qty.: 8.0000 Each(s)/Unit Total : 32.0000 Each(s)

Bolt

M109651 ✓

22.0

MS21042L4

Nut



Comment: Qty.: 12.0000 Each(s)/Unit Total : 48.0000 Each(s)

Nut

Batch: M19085 ✓

23.0

MS21042L4

Nut



Comment: Qty.: 12.0000 Each(s)/Unit Total : 48.0000 Each(s)

Nut

Batch: N/A

Duplicate Step.

24.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

25.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP Do58-677-012

Location: FG 26

PPP Rev: B

AB 06/06/07

(4)

26.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

D 06/06/08

(4)

Job Completion



h 06/06/08

W/O:		WORK ORDER CHANGES					
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

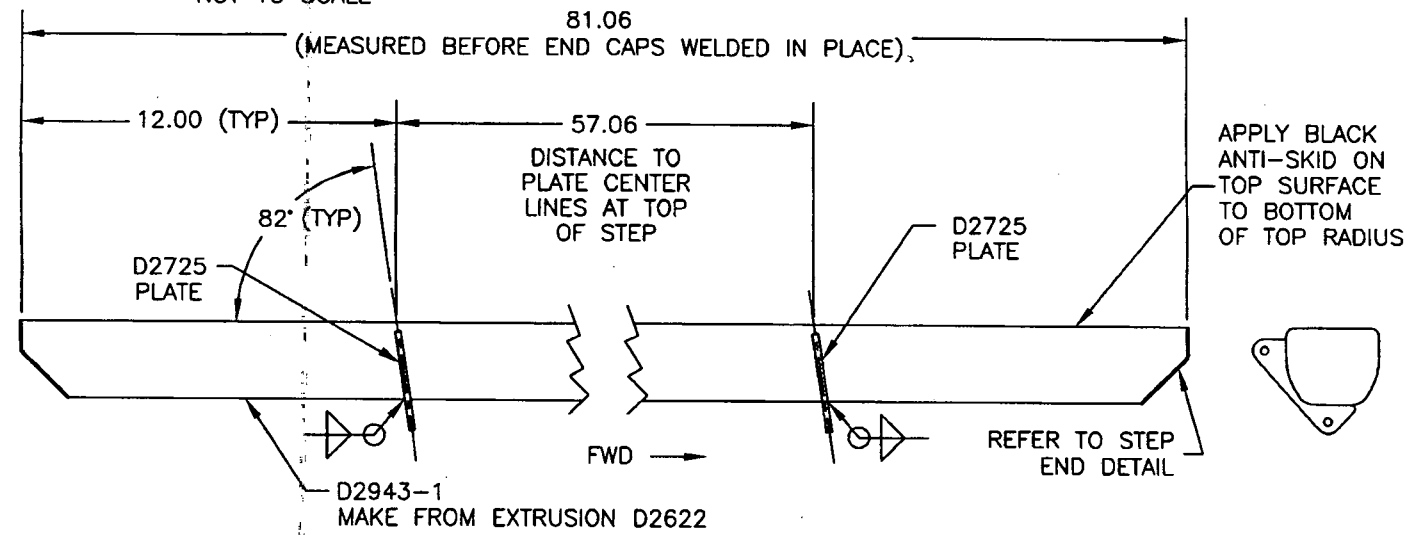
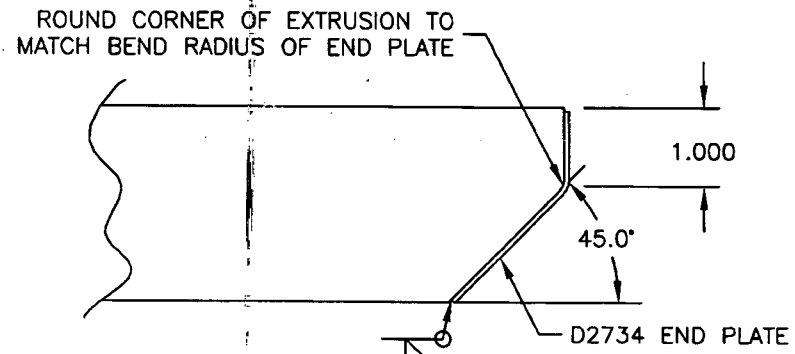
NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____



DESIGN	RF	DRAWN BY	RF	DART AEROSPACE USA, INC.	PORT HADLOCK, WA	REV. B
CHECKED		APPROVED		DRAWING NO.	D2943	SHEET 1 OF 1
DATE	05.11.14			TITLE	OH-58 STEP ASSEMBLY	SCALE
						NTS
A		99.11.19		NEW ISSUE		
B		05.11.14		UPDATE FINISHING NOTE		

NOTE: ALL WELDS SHALL BE 100% VISUALLY INSPECTED BY A QUALIFIED INSPECTOR PER DART QSI 004



D2943-041 LH STEP ASSEMBLY (SHOWN)
D2943-042 RH STEP ASSEMBLY (OPPOSITE)

D2943-041/-042 OH-58 STEP ASSEMBLY PARTS LIST

QTY	QTY	PART NUMBER	DESCRIPTION
X	-041	D2943-041	LH STEP ASSEMBLY
X	-042	D2943-042	RH STEP ASSEMBLY
1	1	D2622-082*	EXTRUSION
2	2	D2725	PLATE
2	2	D2734	END PLATE

*cut per drawing

D2943-041/-042 OH-58 STEP ASSEMBLY NOTES

- 1) MAKE FROM EXTRUSION D2622
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 27349

RELEASED
05.11.28

UNDER REVIEW
06.08.29
RE DESIGN
FOR THIS
W/O 011
06.08.29